



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT400214-1
Job Sheet 186666



Part No: RBT400214-1

Job Qty: 10 ea

Part Name: Frame Weld Mount



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/18

Job Tracking No:

Due Date: 12/4/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT400214 Rev.7 IPP Rev. A 18.06.05 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		12/4/18	0.00	0.00	Start Up Large Fab-7		
100	Large Fab	10 pcs		12/4/18	0.00	5.00	Large Fab 8		
110	QC	10 pcs		12/4/18	0.00	0.00	QC9		
115	QC	10 pcs		12/4/18	0.00	0.00	QC5		
150	Outsource	10 pcs		12/4/18			ATG001-VC	5	
160	Packaging	10 pcs		12/4/18	0.00	0.00	Packaging2		
170	QC	10 pcs		12/4/18	0.00	0.00	QC6		
180	Packaging	10 pcs		12/4/18	0.00	0.00	Packaging3-2		
190	QC21-SA	10 Ea		12/4/18	0.00	0.00	QC21		

Part Op 100 - Weld -7, -9 and -11 as per DWG. Use fixture RBT400214-1-F.

Descriptions: 150 - Issue P/O to ATG; PO 041980 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061 -Certificate of Conformity is required

160 - Receive

180 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT400214-11	Adapter	10 Ea (1 ea)	90-Start up Operation	519341
RBT400214-15	Frame	10 Ea (1 ea)	90-Start up Operation	4-5096409 4-513262
RBT400214-7	Tab	10 Ea (1 ea)	90-Start up Operation	5129242
RBT400214-9	Adapter	10 Ea (1 ea)	90-Start up Operation	5107251

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBT400214-11	10	18	0
	RBT400214-15	10	4	0
	RBT400214-7	10	10	0
	RBT400214-9	10	12	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

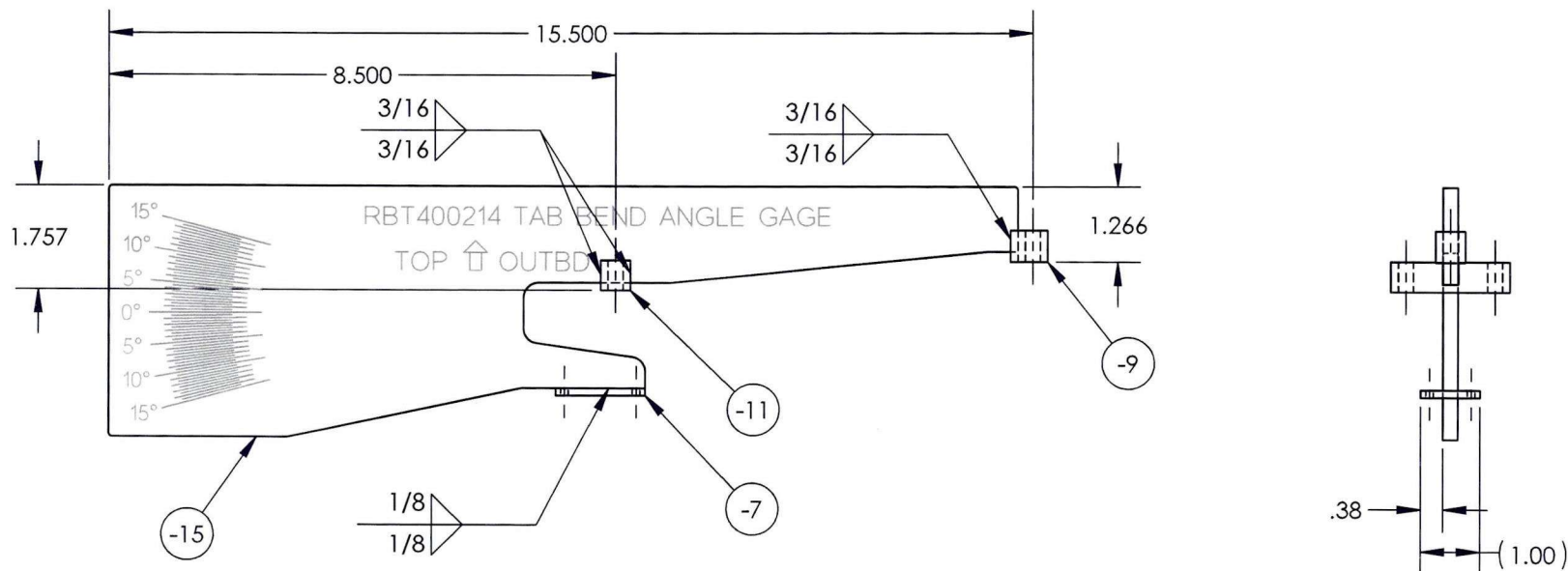
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
123		04/08/20		Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CREATED -1 WELDMENT, ADJUSTED -11 POSITION UP .046 TO CORRECT ALIGNMENT.	10/30/2007	WP	RW
2		ADJUSTED BEARING SUP .090 TO MATCH PURCHASED UNIT.	1/28/2008	WP	DW
3		CH'D FINISH FROM POWDER COAT SAFETY YELLOW.	4/27/2011	RJC	RW
3A		CH'D -1 FINISH FROM ANODIZE BLACK PER R.W.	8/25/2011	RJC	RW
7	16-0240	-1 DELETED DIMS 15.250, 2.150, .089-.095, .203, 1.550, .694, (.190). ADDED DIMS .38, (1.00). ADDED FIXTURE RBT400214-1-F NOTE.	12/1/2016	DPD	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 180666 MWS
18-11-20

NOTE:
USE FIXTURE RBT400214-1-F.

DART AEROSPACE	
TITLE TRIM TAB BENDING GAUGE	
DWG NO. RBT400214-1	REV 7
MAT'L TREAT FINISH RED ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS II	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125/	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: COLE	USED ON MODEL
CHECKED: CLOUGH	BELL 407
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:3	DATE 4/9/2001
SHEET 2 OF 11	

(-1)
FRAME WELDMENT

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>186666</u> Part No. <u>RBT400214</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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- RBT400214-13 AND RBT400214-19 TEFLON TAPE PORT PLASTICS#6093-10 CHANGED FOR McMaster#76475A92 - PER VM <i>* - 1 ASSEMBLY HAS BEEN PAINTED</i>				- This deviation is acceptable. - The fit, form and function of the tool will be as originally intended. <i>- PAINT WILL HAVE NO EFFECT ON FUNCTION OF TOOL</i>				Completed By																																																															
								Lead hand / Supervisor Approval Verification																																																															
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DART
AEROSPACE

12/0 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S134846



Part: RBT400214-1

Job No: 186666

Serial No/Batch: S134846

Revision: 7

Inspector:

Exp Date:

Instructions:

Date: 12/05/18



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041980**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041980
PO Date: 12/6/18
Due Date: 12/21/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186666	RBT400214-1	Frame Weld Mount -Issue P/O to ATG; PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	12/21/18	8 pcs	0 pcs	8 pcs	\$13.88/pcs	\$111.04
2	186949	647.4115	Shim Issue P/O ATG, black anodize and prime as per dwg 647.4115 Rev. N/C	Firmed	-	12/21/18	10 pcs	0 pcs	10 pcs	\$17.33/pcs	\$173.30
Grand Total:											\$284.34

JAS
38
2-89

8 X

DEC 18 2018



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041980

Order Notes

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/14/18 12:38 PM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916831

Date: 17-Dec-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
8 each	Part: RBT400214-1 Frame Weld Mount Anodize per MIL-A-8625F, Type II, Class 2, Red, Water Sealant, .0004-.0010" (.4 - 1 mils). Job: 24321	Rev: 7 PO: PO041980 Line: 1	DAS 38 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>17/12/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			